

Work Order ID 71693

Thursday, July 07, 2011 12:55:21 PM



Page 1

Item ID: D3999-043	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Baffle Assembly, Fwd					
Start Date: 7/7/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 7/21/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/07/07</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3999	A								

100		0.00							
Waterjet									
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								

110		0.00							
QC									
Quality Control	Memo	0.00							
	QC2- Inspect parts off machine FAI/FAIB								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71693

Thursday, July 07, 2011 12:55:21 PM



Page 2

Item ID: D3999-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Baffle Assembly, Fwd

Start Date: 7/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8 u6863					
130 Brake NC Brake NC	Bend as per dwg Memo Bend D3999-3 as per Dwg	0.00 0.00		SB u6865					
180 Small Fab Small Fab	 Memo Assemble as per dwg	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71693

Thursday, July 07, 2011 12:55:21 PM



Item ID: D3999-043	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Baffle Assembly, Fwd					
Start Date: 7/7/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 7/21/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 Packaging Packaging	Identify as per dwg & Stock Location: <u>11A</u> Memo	0.00 0.00				4	0		
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				OK 11/08/11			

11-08-10
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:55:18 PM

Page 1

Work Order ID: 71693

Parent Item: D3999-043

Parent Item Name: Baffle Assembly, Fwd




Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 09.12.16 new issue Prelim EC verified by:DD IPP rev B
10.05.10 ecn 10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	212.9456	2.66	5.6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		212.9455684							
				116308		28.4755684							
				117285		184.47							
D3999-5  Angle		Manufactured	No			180	Each	12.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		12							
				71295		12							
MS20470AD4-4  Rivet, Universal Head		Purchased	No			180	Each	1,160.000	12	24			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST139		618							
				117423		618							
				ST319		542							
				116188		476							
				116391		66							

8.8 ~~8~~ 11/07/29

ES 11/08/09

8

ES 11/08/09

48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

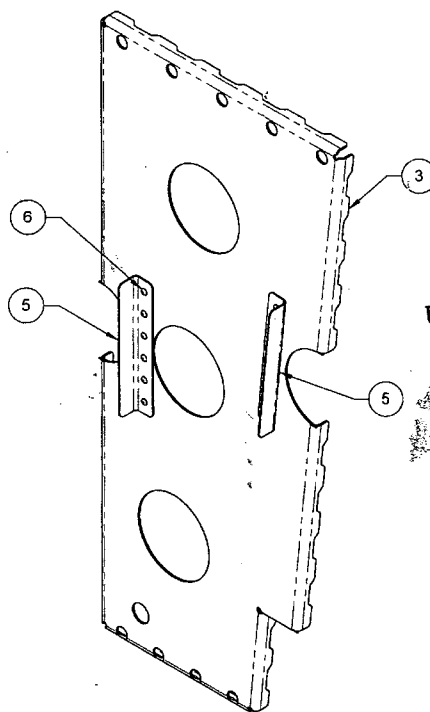
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

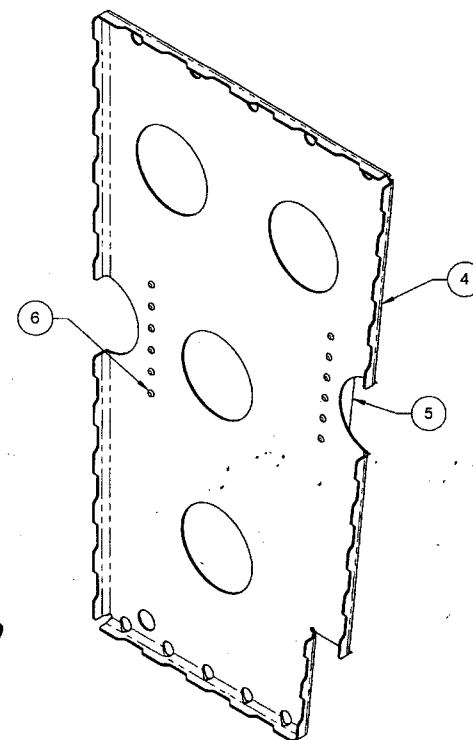
ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X		D3999-041	BAFFLE ASSEMBLY, AFT	JCA-M47-1-02
2		X	D3999-043	BAFFLE ASSEMBLY, FWD	JCA-M47-1-03
3	1		D3999-1	BAFFLE	
4		1	D3999-3	BAFFLE	
5	2	2	D3999-5	ANGLE	
6	12	12	MS20470AD4	RIVET	



D3999-041 BAFFLE ASSEMBLY, AFT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71693

CL1107/07



D3999-043 BAFFLE ASSEMBLY, FWD

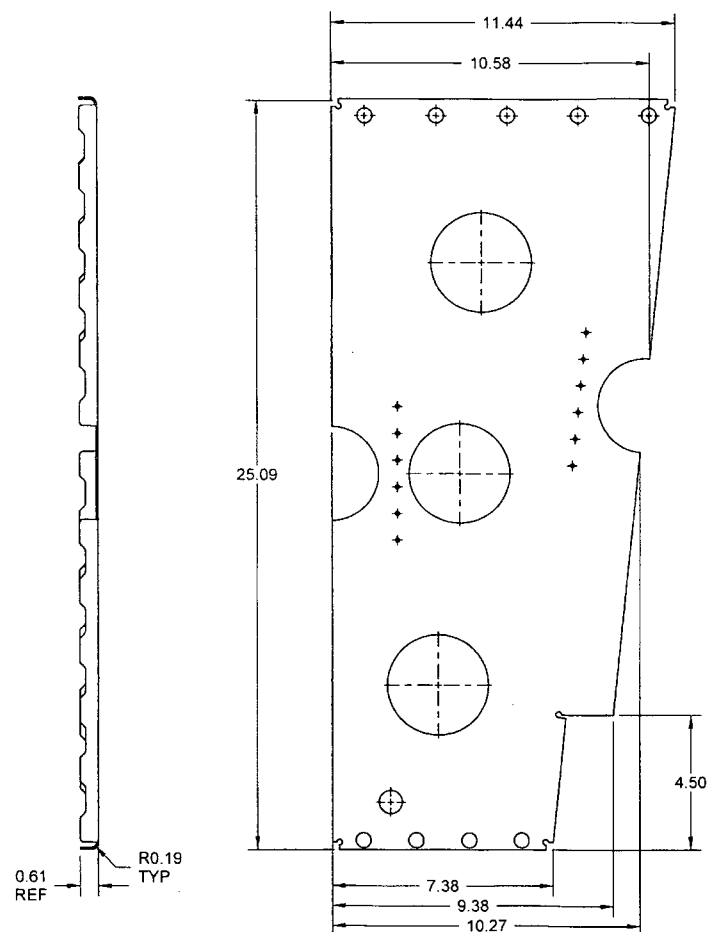
RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3999-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT (-041): 1.51 lbs
- 8) WEIGHT (-043): 1.84 lbs

A	NEW ISSUE	DESCRIPTION	BY	DATE
REV.				
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3999	SHEET 1 OF 12	
APPROVED		TITLE	SCALE	
DE APPR.		BAFFLE	NTS	
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-1	REF JCA-M47-1-02



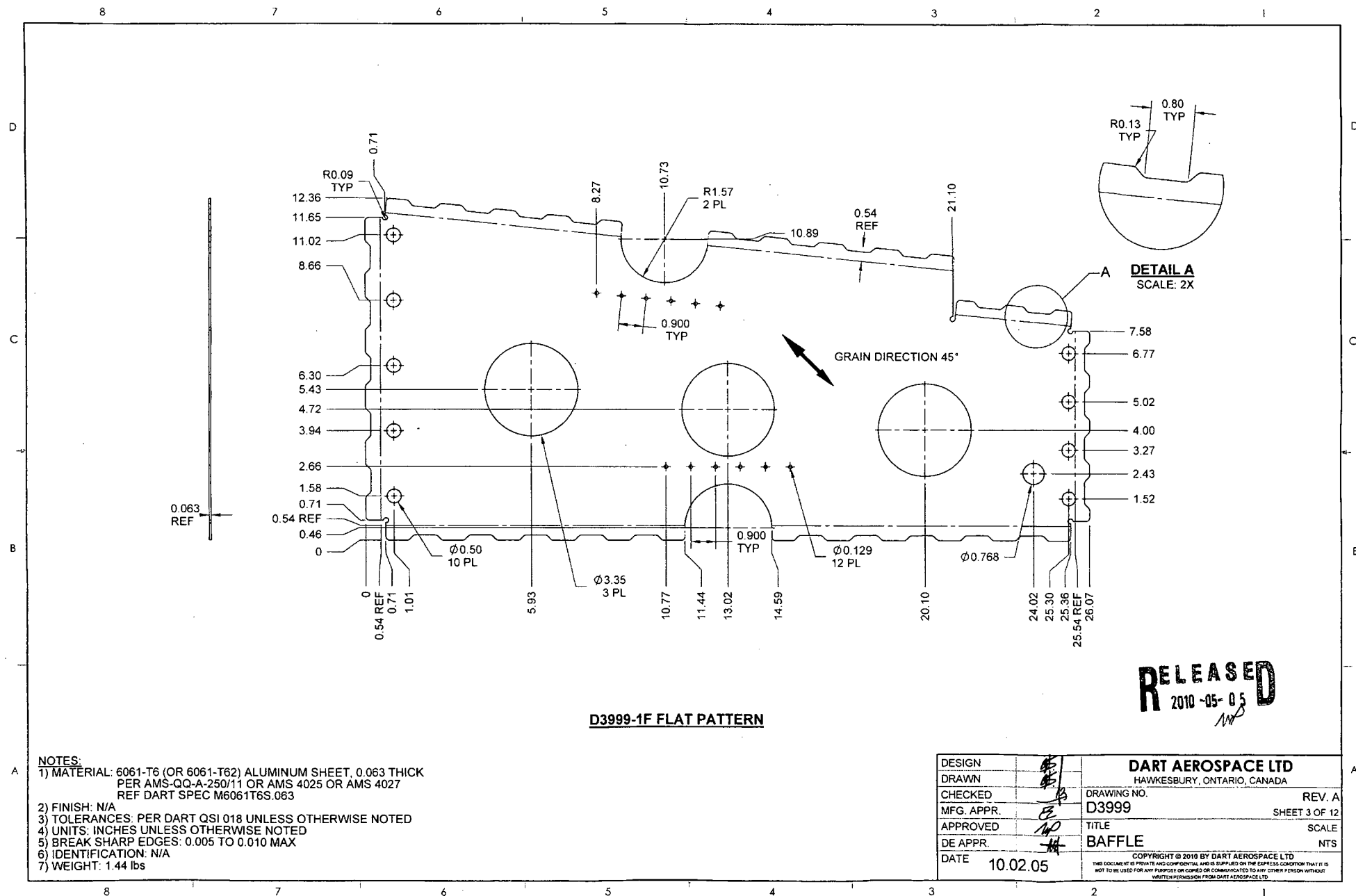
D3999-1 BAFFLE

NOTES:

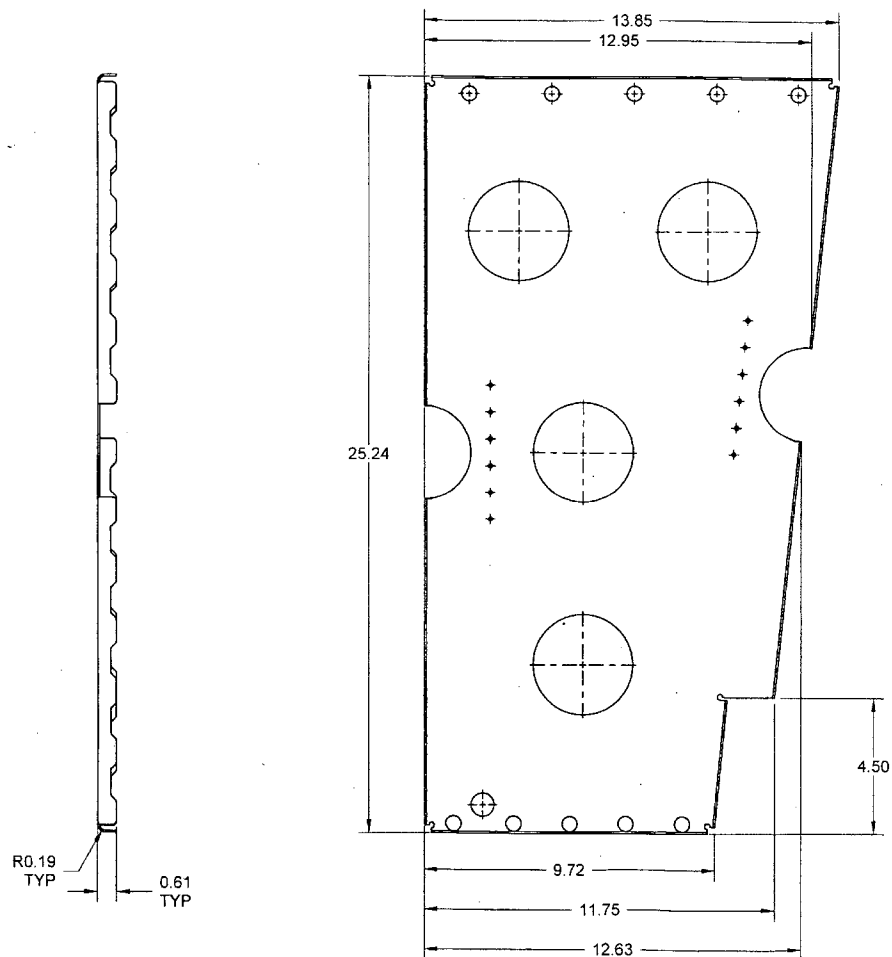
- 1) MATERIAL: MADE FROM D3999-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.44 lbs

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2010-05-05
MD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.			SHEET 2 OF 12
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-3	REF JCA-M47-1-03



D3999-3 BAFFLE

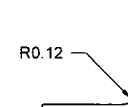
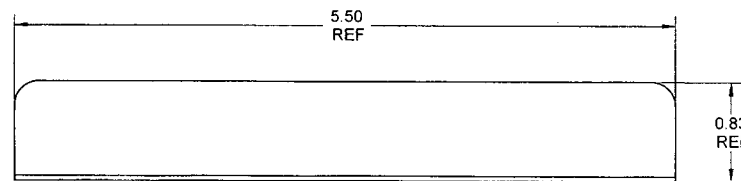
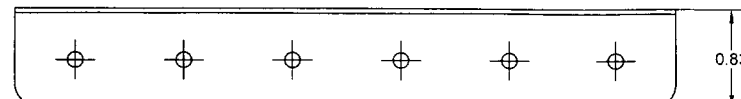
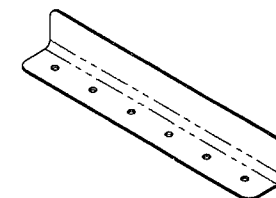
NOTES:

- 1) MATERIAL: MADE FROM D3999-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.77 lbs

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MFG. APPR.		D3999	SHEET 4 OF 12
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2010-05-03

8	7	6	5	4	3	2	1
DART AEROSPACE PART NUMBER		JOHN CAMERON AVIATION PART NUMBER					
D3999-5		REF JCA-M47-1-02 REF JCA-M47-1-03					

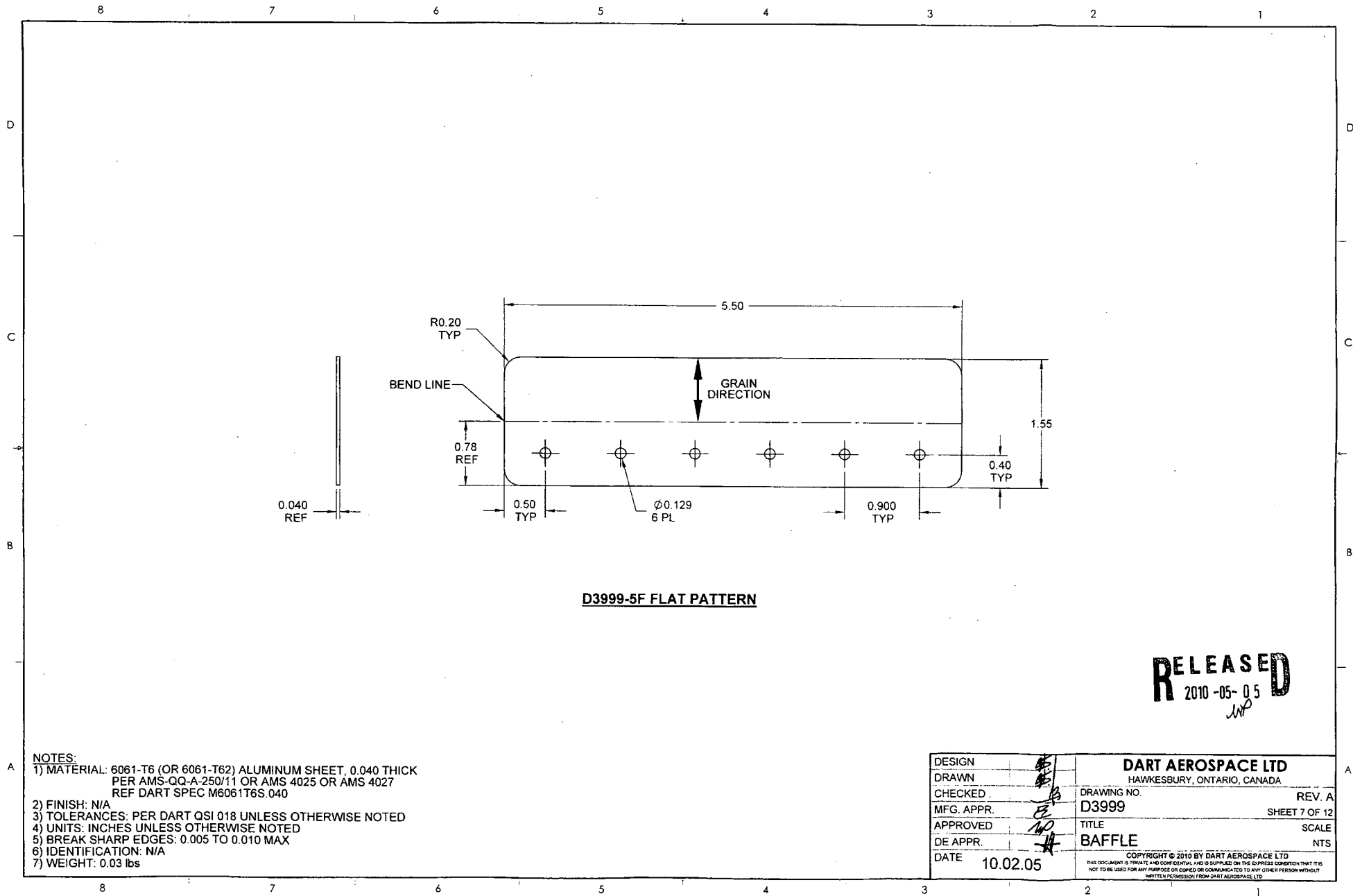


D3999-5 ANGLE

RELEASED
2010-05-05
MP

- NOTES:
- 1) MATERIAL: MADE FROM D3999-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3999	SHEET 6 OF 12
APPROVED		TITLE	SCALE
DE APPR.		BAFFLE	NTS
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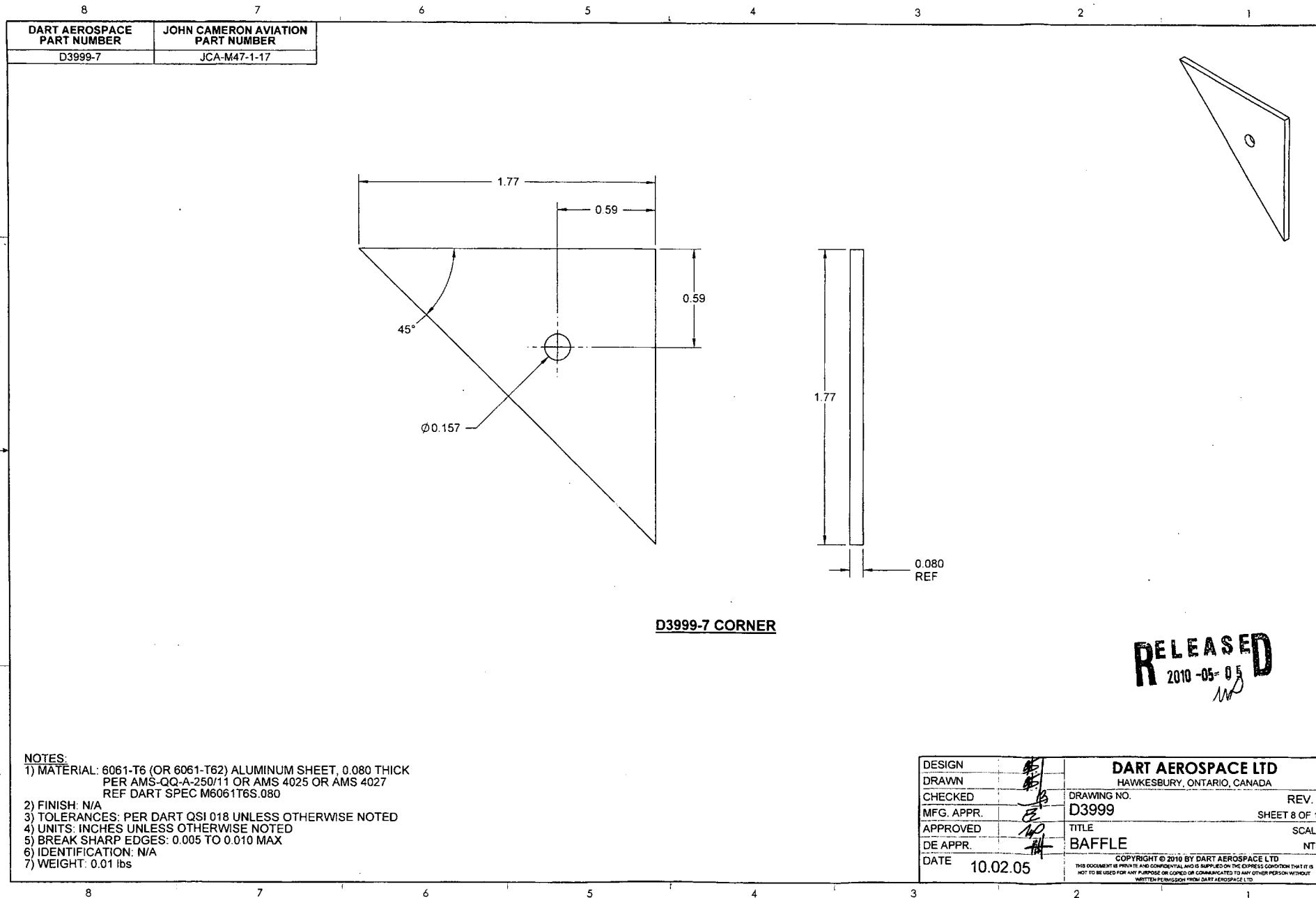


RELEASED
2010-05-05
JNP

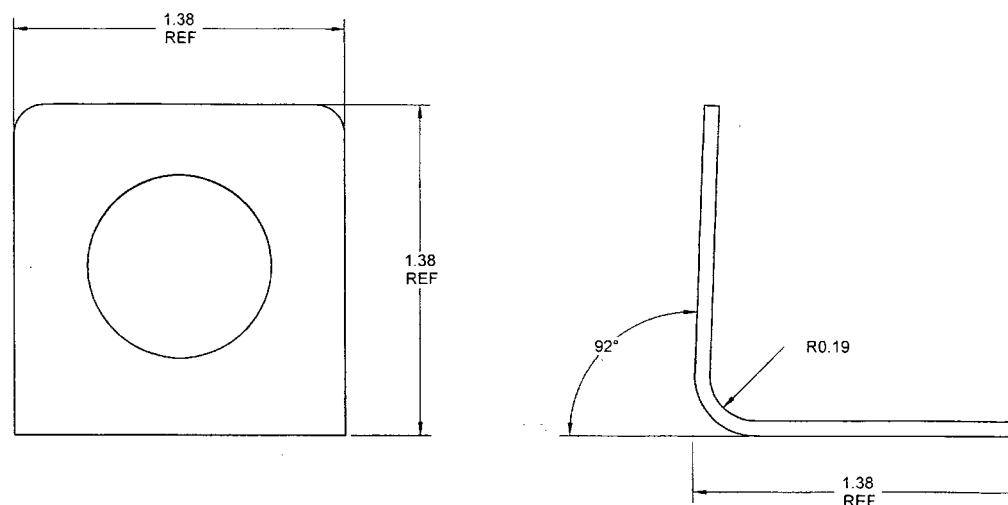
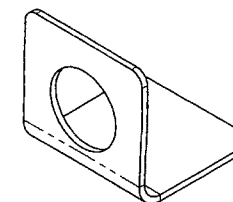
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3999	REV. A
MFG. APPR.		TITLE BAFFLE	SHEET 7 OF 12
APPROVED		DE APPR.	SCALE
DATE	10.02.05		NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-9	JCA-M47-1-18



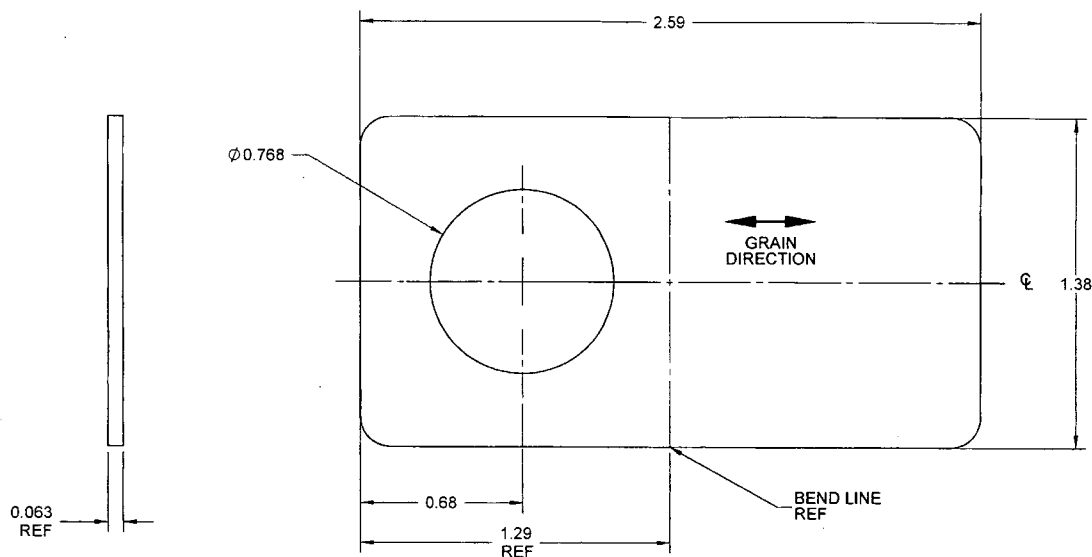
D3999-9 ANGLE

RELEASED
2010-05-05
AM

NOTES:

- 1) MATERIAL: MADE FROM D3999-9F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3999	REV. A
MFG. APPR.			SHEET 9 OF 12
APPROVED		TITLE BAFFLE	SCALE
DE APPR.			NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3999-9F FLAT PATTERN

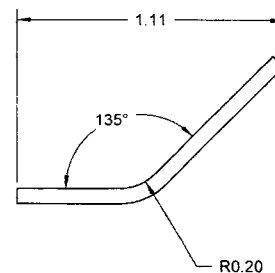
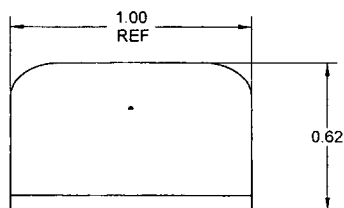
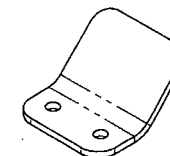
RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S0.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3999	SHEET 10 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAFFLE	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-11	JCA-M47-1-19



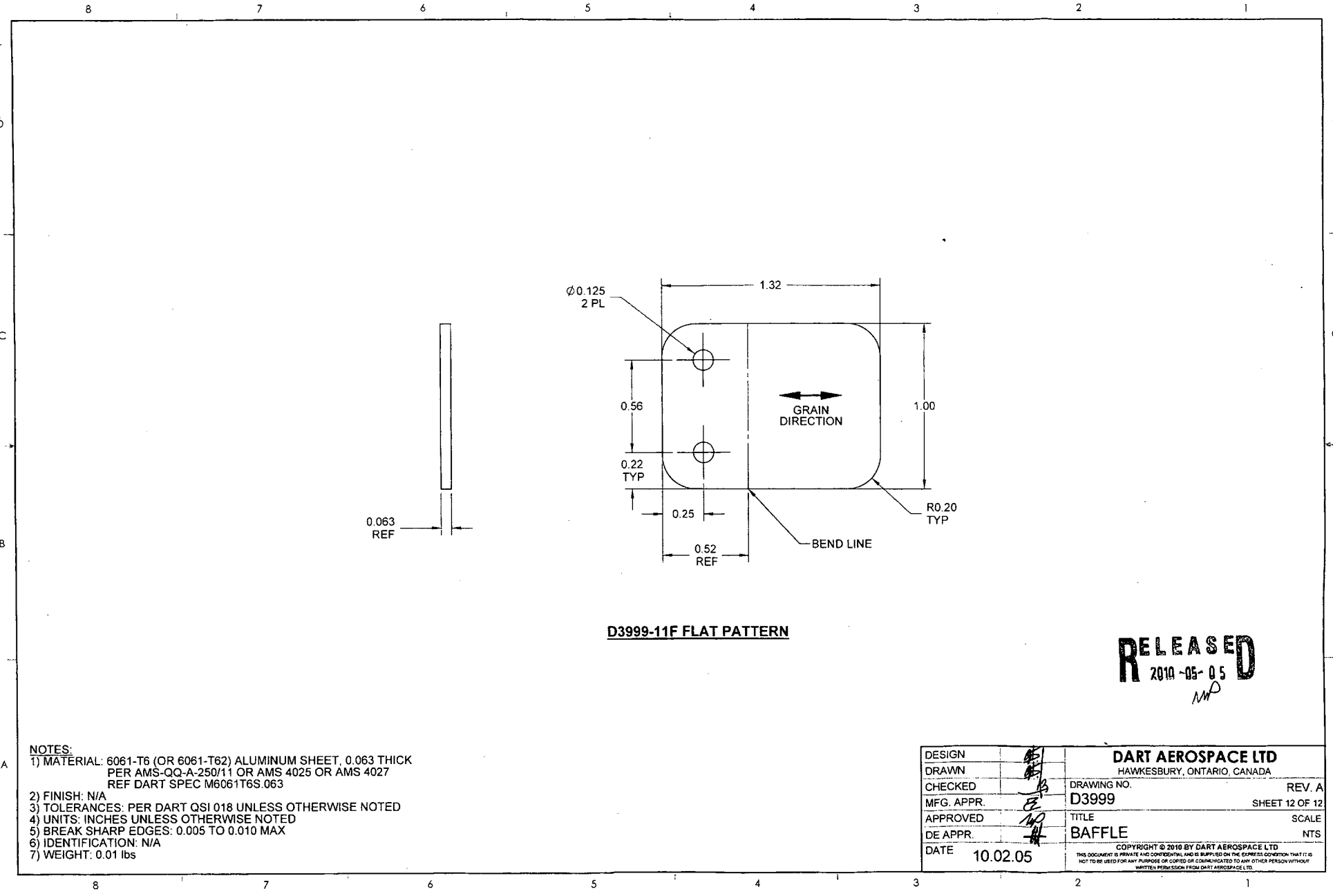
D3999-11 EARTH TAB

RELEASED
2010-05-05
MD

NOTES:

- 1) MATERIAL: MADE FROM D3999-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>MD</i>	DART AEROSPACE LTD	
DRAWN	<i>MD</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MD</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MD</i>	D3999	SHEET 11 OF 12
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	BAFFLE	NTS
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RELEASED
2010-05-05
MD

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.01 lbs

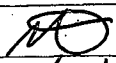

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D3999	SHEET 12 OF 12
MFG. APPR.		TITLE	SCALE
APPROVED		BAFFLE	NTS
DE APPR.		COPYRIGHT © 2016 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	10.02.05		

DART AEROSPACE LTD		Work Order: 71693
Description: Baffle Assy F. Pattern		Part Number: 3999-3
Inspection Dwg: 3999	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.76	$\pm .030$	14.75	—		RAOY	Tape
12.96	$\pm .030$	12.96	—		"	
10.21	$\pm .030$	10.21	—		"	
9.91	$\pm .030$	9.91	—		"	
7.46	$\pm .030$	7.46	—		"	
5.77	$\pm .030$	5.77	—		RAOY	Tape
4.71	$\pm .030$	4.71	—		"	
3.61	$\pm .030$	3.61	—		"	
2.67	$\pm .030$	2.67	—		"	
1.96	$\pm .030$	1.96	—		"	
.71	$\pm .030$.71	—		"	
1.02	$\pm .030$	1.02	—		RAOY	
5.61	$\pm .030$	5.61	—		"	
10.77	$\pm .030$	10.77	—		"	
13.02	$\pm .030$	13.02	—		"	
20.10	$\pm .030$	20.10	—		"	
24.75	$\pm .030$	24.75	—		"	
25.38	$\pm .030$	25.38	—		"	
1.46	$\pm .030$	1.46	—		RAOY	Tape
2.43	$\pm .030$	2.43	—		"	
3.46	$\pm .030$	3.46	—		"	
5.33	$\pm .030$	5.33	—		"	
7.21	$\pm .030$	7.21	—		RAOY	Tape

Measured by: 	Audited by: 	Prototype Approval:
Date: 11/07/29	Date: 11/08/23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

